

POSITIVE RECALL



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

U/R

EFFECTIVE 16/1/13
RELEASED 1/10 DATE 26/5/2019
D3304-043

Job Sheet 197261



DAS
55
9-89

Part No: D3304-043

Job Qty: 4 pcs

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: New

Job Created: 7/3/19

Job Tracking No:

Due Date: 7/5/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF 19-568 DWG REV C IPP: D 04.11.26 Revised Step 7 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	4 pcs	7/5/19	7/5/19	0.00	1.39	Bandsaw - 1			
110	Conventional Lathe - 1 - B4B	4 pcs	7/5/19	7/5/19	0.00	2.40	Conventional Lathe - 1 - B4B			
							Conventional Lathe - 2 - B4B			
120	QC 2	4 pcs	7/5/19	7/5/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			

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Container No: S199423



Part: D3304-043

Job No: 197261

Serial No/Batch: S199423

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/22/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

130 QC 8	4 pcs	7/5/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	mk 19/07/22
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
QC 8 - 45					
QC 8 - 49					
QC 8 - 58					
QC 8 - 8					
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 1 (A)					
QC 8 - 47					
QC 8 - 40					
QC 8 - 52					
QC 8 - 23					
QC 8 - 57					
140 Small Fab - 2 - B4B	4 pcs	7/5/19	0.00 2.41	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	JUL 25 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 QC 5	4 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
QC 5 - 40					
160 Large Fab - Welded Assy-2-B4B	4 pcs	7/5/19	0.00 2.13	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	

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DAS
40
9-89

JUL 25 2019

EL

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				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
170 QC 9	4 pcs	7/5/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
180 QC 5	4 pcs	7/5/19	0.00 0.00	QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
190 Powdercoat - 3 Grey Sand - B4B	4 pcs	7/5/19	0.00 0.29	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200 QC 3	4 pcs	7/5/19	0.00 0.00	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	

210 Small Fab - 3 - B4B	4 pcs	7/5/19	0.00 2.41	QC 3 - 81	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	JUL 26 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
220 QC 5	4 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS
				QC 5 - 30	40
				QC 5 - 40	JUL 26 2019 9-89
230 Packaging 3-1 - Stock - B4B	4 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	OR Bin: ST459 ✓
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
240 QC 21 - SA	4 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	Bin: ST459 ✓
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - (Manufacture as per dwg)
Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Weld per dwg A/R S.S. rod Batch: M138979)
170 - (QC9- Inspect visual per QSI004- Fuslon Welds)

- 180 - (QC5- Inspect part completeness to step on W/O)
- 190 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3)
- 200 - (QC3- Inspect Part Finish)
- 210 - MANUFACTURE LANDYARD AS PER D2690-10 DWG
- 220 - (QC5- Inspect part completeness to step on W/O)
- 230 - (Identify as per dwg & Stock Location:_____)
- 240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.875W.065	304 Round Tube .875 X .065W	7.4168 ft (1.8542 ea)	100-Bandsaw - 1	5126574 - M138403
BLBS-0016	Pip Pin	4 pcs (1 ea)	210-Small Fab - 3 - B4B	814443
CBL-1240	Cable	4.1664 ft (1.0416 ea)	210-Small Fab - 3 - B4B	8157380
CBL-460	Loop Sleeve	8 Ea (2 ea)	210-Small Fab - 3 - B4B	8187877
D3304-7	Bracket	4 pcs (1 ea)	210-Small Fab - 3 - B4B	2x F150459 2x F163474

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304TR0.875W.065	7	28	0
210-Small Fab - 3 - B4B	BLBS-0016	4	16	0
	CBL-1240	4	54	0
	CBL-460	8	1,037	0
	D3304-7	4	5	0

Part Specifications

Specifications could not be found.

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Job: _____		DISPOSITION				DEPARTMENT/PROCESS											
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐				Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:		QTY Affected :		MRB (QS1042)												
Description Work Order Deviation					Disposition												
Root Cause					FAULT CATEGORY												
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐					Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:			Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			